

Claims

1. Water soluble salt cores manufactured by compacting a mixture of water soluble salts and a binder under pressure and by subsequently subjecting said compacted
5 mixture to a thermal treatment,
characterized in
that the binder is an inorganic phosphate or a mixture of inorganic phosphates with a fraction of between 0.5 and 10 wt. % of said mixture.
- 10 2. The water soluble salt cores as set forth in claim 1,
characterized in
that the binder contains a fraction of an inorganic borate.
3. The water soluble salt cores as set forth in claim 1 or 2,
15 characterized in
that the mixture contains a fraction of between >0 and 10 wt. % of a parting agent.
4. The water soluble salt cores as set forth in claim 1, 2 or 3,
characterized in
20 that the inorganic phosphate is a monoaluminium phosphate.
5. The water soluble salt cores as set forth in claim 1, 2 or 3,
characterized in
that the inorganic phosphate is a boron phosphate.
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6. The water soluble salt cores as set forth in claim 1, 2 or 3,
characterized in
that the inorganic phosphate is a sodium polyphosphate.
- 30 7. The water soluble salt cores as set forth in any one of the afore mentioned claims,
characterized in
that thermal treatment occurs at temperatures of less than 730 °C.